

Work Order ID 88832

Tuesday, August 07, 2012 10:03:13 AM

88832

Ship today Page 1

Item ID: DSI 9356-011

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Basket Repair

Stop ***NS2***

Start Date: 8/7/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 8/7/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: *MR* Date: *12-08-07*

Tooling:

Date:

Run Start ***NR1***

QC: Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

DSI9356

B

100

0.00

100

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP DSI 9356-011 CHG001

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

DAS 16 12/08/07

12/8/07

12/8/07

DAS 16 12/08/07

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											

FAULT CATEGORY									
Landing Gear			General						
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain	<input type="checkbox"/> Ovalized	<input type="checkbox"/> Pressure/Forced					
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware	<input type="checkbox"/> Over/Under tolerance	<input type="checkbox"/> Temperature/Cure					
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete	<input type="checkbox"/> Part Incorrect	<input type="checkbox"/> Weld					
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Part Lost/Missing	<input type="checkbox"/> Wrong Stock Pulled					
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance	<input type="checkbox"/> Part Moved						
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Positioned Wrong						
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread	<input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Other					
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset							
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration							
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence							
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions							

Work Order ID 88832

Tuesday, August 07, 2012 10:03:13 AM

88832

Page 2

Item ID: DSI 9356-011

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Basket Repair

Stop *NS2*

Start Date: 8/7/2012 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 8/7/2012 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP DSI 9356-011 Location: _____								12/8/754
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									MLJ 12/08/07 MLJ 12/08/07

Picklist Print

Tuesday, August 07, 2012 10:03:12 AM

Page 1

Work Order ID: 88832

Parent Item: DSI 9356-011

Parent Item Name: Basket Repair


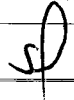



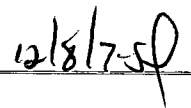
Start Date: 8/7/2012

Required Date: 8/7/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 11.11.29 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
 AN4-15A Bolt		Purchased	No			110	Each	288.0000	4	4			
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				358		100							
				121652		100							
				GA		100							
				120449		100							
				ST358		88							
				118706		3							
				120422		1							
				122141		84							
 BLRS-020 Pip Pin		Purchased	No			110	Each	15.0000	4	4			
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST283		15							
				121322		5							
				122168		10							
 D3907-1 Bushing		Manufactured	No			110	Each	32.0000	8	8			
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				WA		32							
				86059		32							

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

DART SERVICE INSTRUCTION

TO AMEND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-607

REF, CANADIAN STC: SH94-14

FAA STC: SR00213NY

EASA STC: EASA.I.R.M.S.1405

IN CASES WHERE THE MOUNTING HOLES AT THE BASE OF THE D350-607-041/-043/-045/-047 BASKET ARE ELONGATED DUE TO WEAR OR DAMAGE, IT IS ACCEPTABLE TO REPAIR THE HOLES WITH THE FOLLOWING REPAIR PROCEDURE:

REFERENCE ONLY

REPAIR PROCEDURE:

- 1) ENLARGE THE INSTALLATION HOLES ON THE D2325 GUSSETS PER FIGURE 1 AND DEBURR SHARP EDGES.
- 2) INSTALL THE D3907-1 BUSHING BY T.I.G WELDING PER MIL-STD-2219/AMS-STD-2219 CLASS "C" USING ER308L FILLER ROD AS SHOWN IN DETAIL B.
- 3) TOUCH UP PAINT IN ACCORDANCE WITH ICA-D350-607.
- 4) RE-INSTALL THE BASKET IN ACCORDANCE WITH ICA-D350-607 SUBSTITUTING THE INSTALLATION HARDWARE PER TABLE 1.

TABLE 1

BOLT			QUICK RELEASE PIN		
EXISTING	REPLACEMENT	QTY	EXISTING	REPLACEMENT	QTY
AN4-12A	AN4-15A	4	BLRS-010	BLRS-020	4

PARTS LIST

ITEM	QTY -011	PART NUMBER	DESCRIPTION
	X	DSI 9356-011	BASKET REPAIR KIT
1	8	D3907-1	BUSHING
7	4	AN4-15A	BOLT
8	4	BLRS-020	QUICK RELEASE PIN

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: D. SHEPHERD (DE # 02)

DATE: 09.03.11
CERT. NO.: SH94-14
ISSUE NO.: 4

B	DSI UPDATED TO MAKE DSI INTO KIT AS WELL AS REPAIR INSTRUCTIONS. TITLE UPDATED. SEE NCR 09-036 FOR DETAILS.	AJS	09.03.11
A	NEW ISSUE	MB	06.09.28
REV.	DESCRIPTION	BY	DATE
DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	N/A	DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9356	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		ELONGATED HOLE REPAIR KIT	NTS
DATE	09.03.11	COPYRIGHT © 2006 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT SPECIFIC PERMISSION FROM DART AEROSPACE LTD.</small>	

REFERENCE ONLY

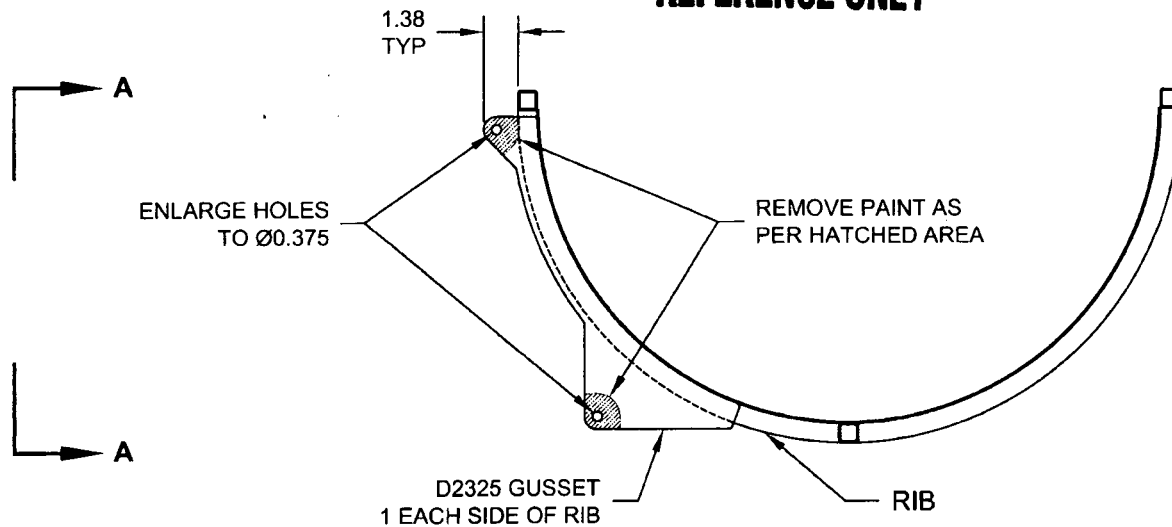
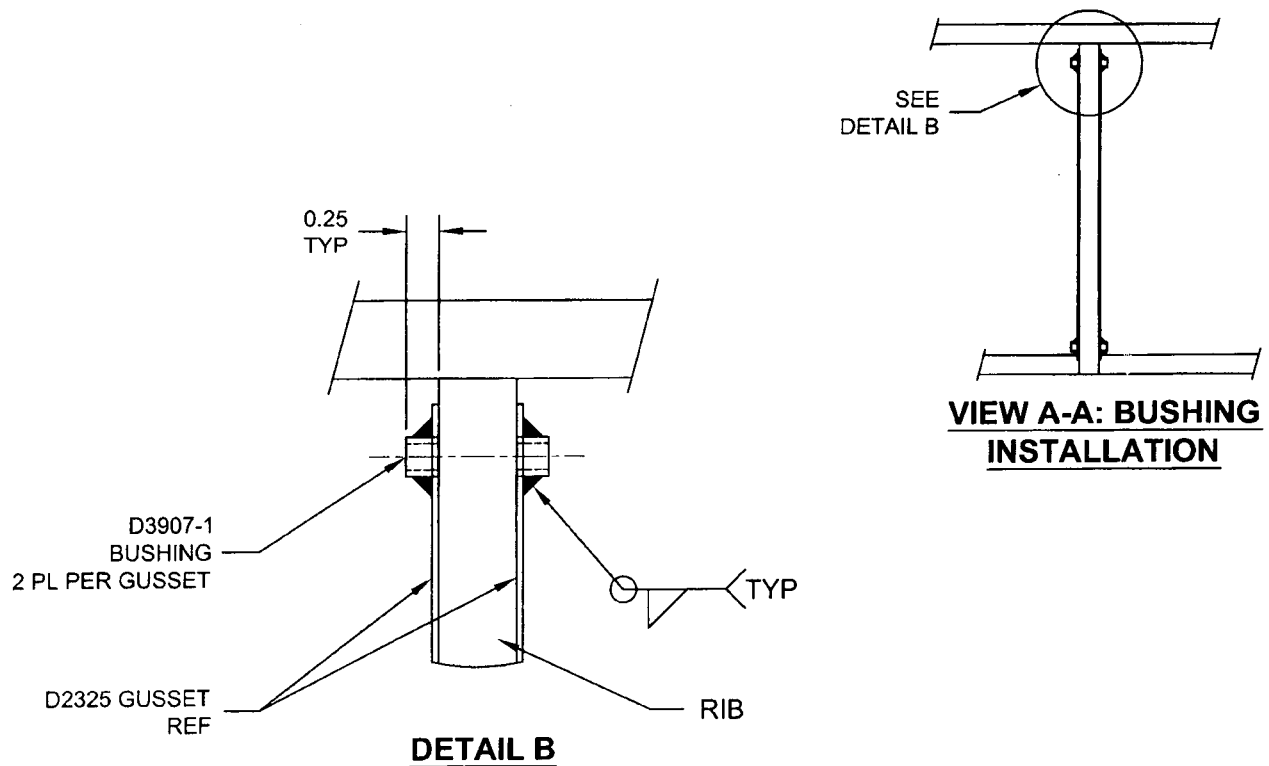


FIGURE 1: WELDING PREPARATION



CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 09.03.11
CERT. NO.: SH94-14
ISSUE NO.: 4

DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ADS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9356	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	ELONGATED HOLE REPAIR KIT	NTS
DATE	09.03.11	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OTHER THAN THAT FOR WHICH IT WAS ORIGINALLY DESIGNED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	

